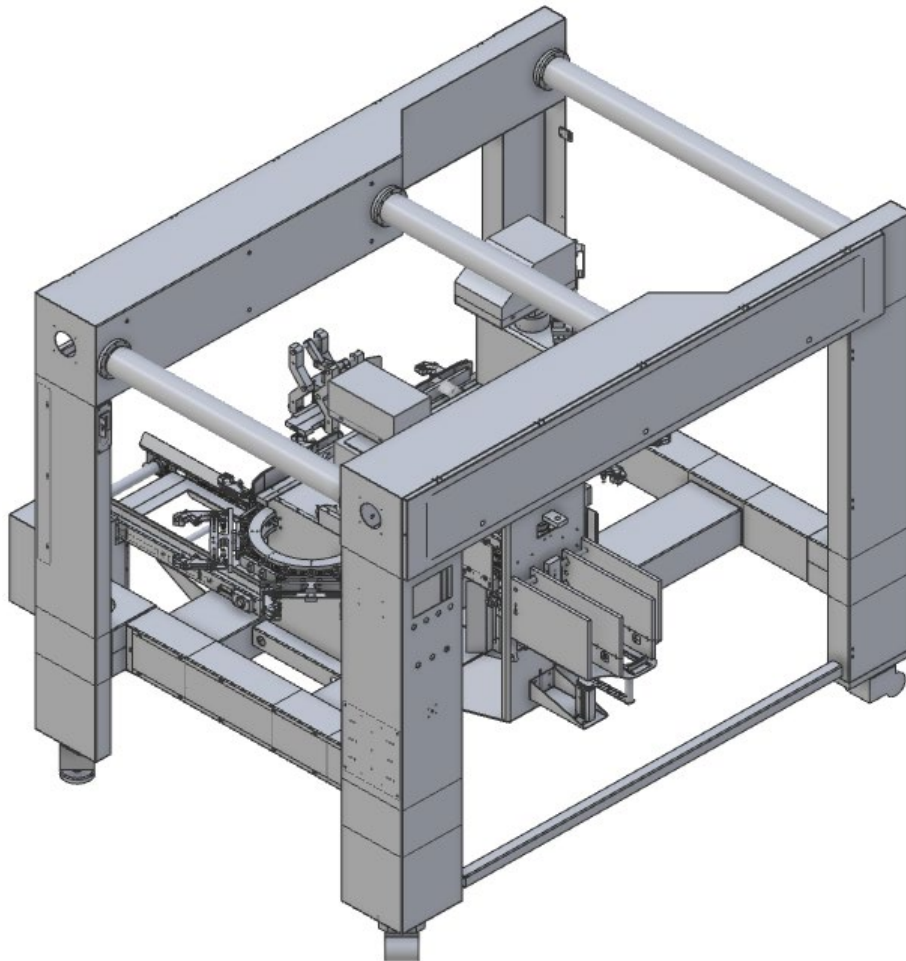




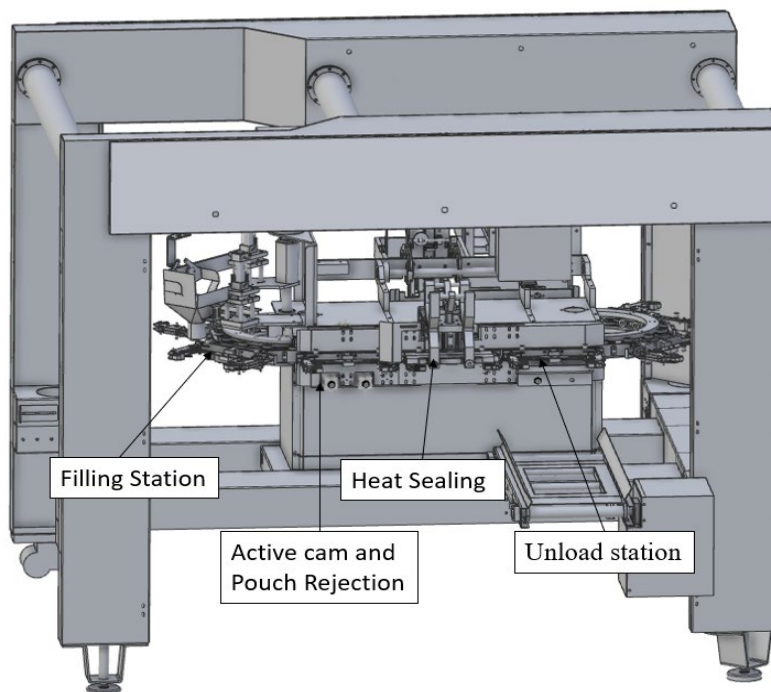
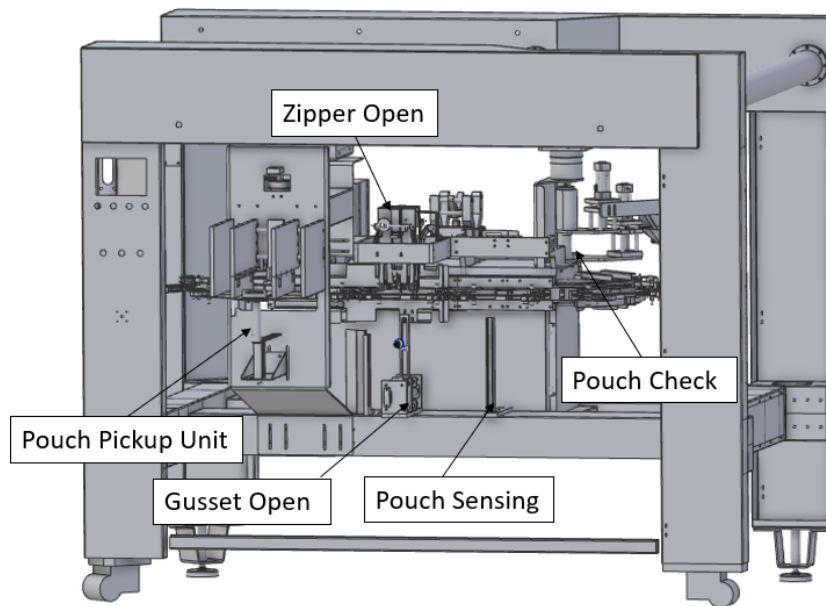
RT-Pack 360



Quick start manual

1.Introduction

- MACHINE LAYOUT



2. TECHNICAL DATA

Machine Type - Automatic Pick, Fill & Seal Machine

Control - PLC (Programmable Logic Control)

Temperature Controller - PID Type

Pouch Type - Pre-formed All Types

Pouch Size

	Min. (mm)	Max. (mm)
Width	100	240
Length	100	300

Speed - Maximum 25 to 30 pouches/min (Dry run)

Power Consumption - 7 kW

Power Supply - 220V/AC/Three Phase

Pneumatic Utility -Compressor: 30 CFM, 10 Bar

Feature - Easy Change over to Various Pouch Size Sensor to Avoid Product &Pouch Wastage

Packaging Material - Heat Sealable/Machinable Laminate Pouches

Ambient Conditions - Temperature – 40 Degree Celsius

Recommended Relative Humidity – 56% Max.

Product Temperature – 50 Degree Celsius

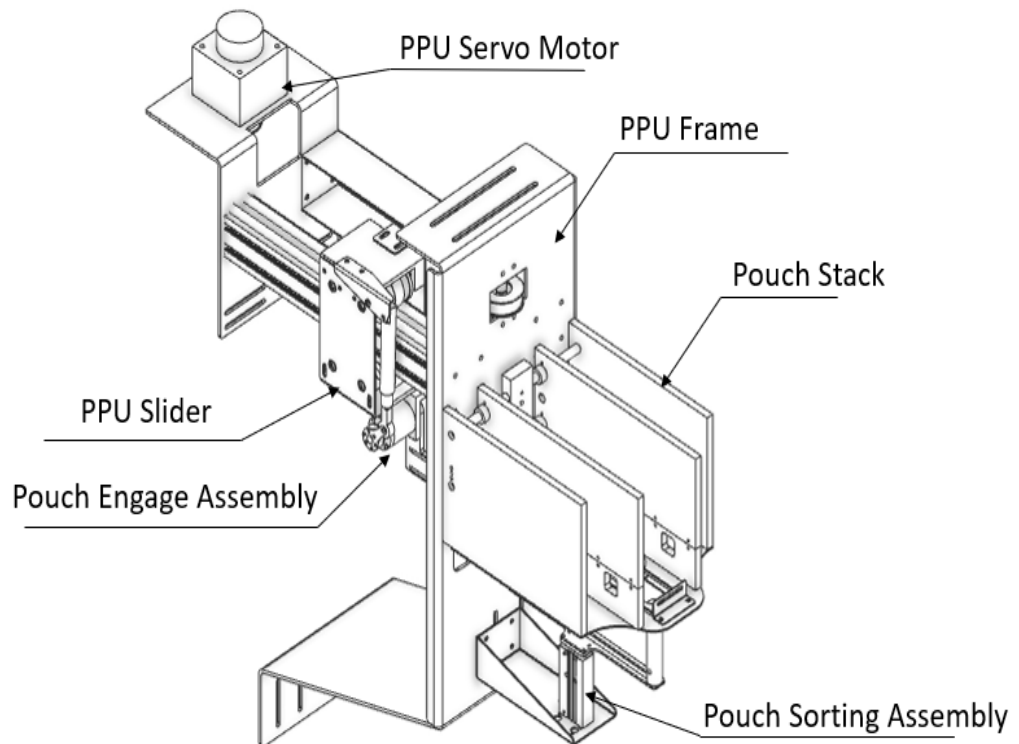
3.Connections

1. Connect 3 phase 220V Power connection in LOTO located in side panel.
2. Connect Air supply to FRL Unit located near unload station with 16mm Pneumatic tubing.

4.Assembly

1. PPU Assembly

- Assemble Stack assembly and Pouch sorting assembly on the PPU Frame with Bolts as shown in fig below
- Connect pneumatic connections



2.sealing assembly

- Assemble the sealing assembly at Heat Sealing station
- Connect both heaters and Thermocouples
- Connect Pneumatic connections

5.STARTING PROCEDURE

- Switch ON main supply
- Switch ON LOTO
- Provide air supply
- Check air pressure (Maintain between 6-6.5 bar)
- Check servo home positions
- Check and set home position of servo motors as explain in chapter 6

6. SETTING SERVO MOTOR HOME CONDITION

6.1 PPU SERVO MOTOR



Fig indicates PPU HMI screen. To set home condition, follow steps as below –

- Set PPU at back condition on the top of the gripper using JOG REVERSE.
- Close the PE Pneumatic cylinder from the manual operation
- On the Top and Bottom Cam from the manual operation
- PE arm and gripper inserts should be in line
- Press and Hold the SET AS HOME until current position becomes zero.
- You have achieved PPU servo motor home position.

6.2 OPERATION SERVO MOTOR

POUCH OPEN SERVO		Last Operation Time : 0.00 Sec	
SPEED		JOG 0000 rpm	AUTO 0000 rpm
ROTATION		0000 deg	
ACCELERATION TIME		00000 mSec	
DEACCELERATION TIME		00000 mSec	
		Reverse Dwell @ : 0000 deg	
JOG FWD		JOG REV	MANUAL OPERATE
SET AS HOME		START HOMING	
Position : 0000 deg		Load: 000.0 000.0 %	
24/12/23 14:10:45 INDEXING ERROR – SENSOR NOT SENSED [X0] [X1]			
MENU	INDEX SETTINGS	PPU SETTINGS	POUCH OPEN SETTINGS
POUCH CHECK SETTINGS	RESET		

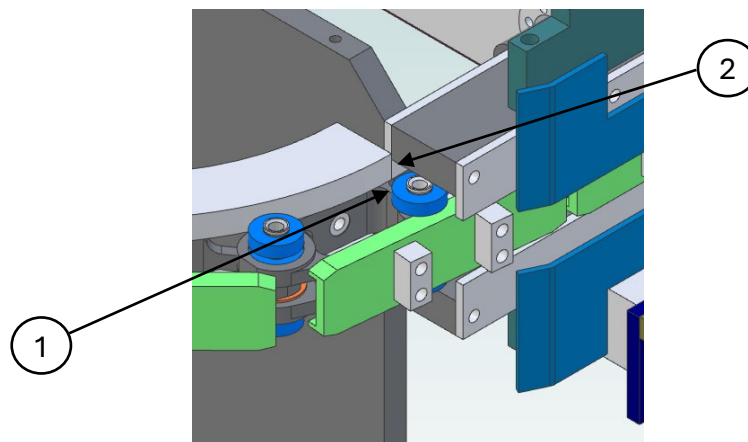
Fig indicates Operation HMI screen. To set home condition, follow steps as below –

- Press Emergency Stop button and take both the Moving plates to extreme end
- Hold the plates and release the Emergency stop button
- Jog Forward the moving plates to 5 deg. and press and hold the HPR for 2 sec
- Jog forward the plates Until Both the Fingers almost touch each other
- At that position, the value reflecting on the current position field to be set at the Rotation field
- Now manual operate and check both home position and job position
- You have achieved Pouch open servo motor home position.

6.3 INDEXING SERVO MOTOR



Fig: Indexing HMI screen. To set home condition, follow steps as below –



- Jog Forward the indexing assembly and ensure the gripper assembly is in line with PPU assembly at station 1
- Align the centre of Link pin 1 (shown in fig) with the track assembly (2)
- Press HPR and hold for 2 sec.
- You have achieved indexing servo motor home position.

6.4 POUCH CHECK UNIT

POUCH CHECK SERVO		Last Operation Time : 0.00 Sec	
SPEED	Jog 00 Auto [F] 00000 [R] 00000 rpm		
ROTATION		00000 deg	
ACCELERATION TIME	[F] 00000 [R] 00000 mSec		
DEACCELERATION TIME	[F] 00000 [R] 00000 mSec		
JOG FORWARDJOG REVERSESET AS HOMEMANUAL OPERATESTART HOMING			
Position :	0000 deg	Load :	000.0 000.0 %
24/12/23 14:17:25 INDEXING ERROR - SENSOR NOT SENSED [X0] [X1]			
MENU	INDEX SETTINGS	PPU SETTINGS	POUCH OPEN SETTINGS
			POUCH CHECK SETTINGS
			RESET

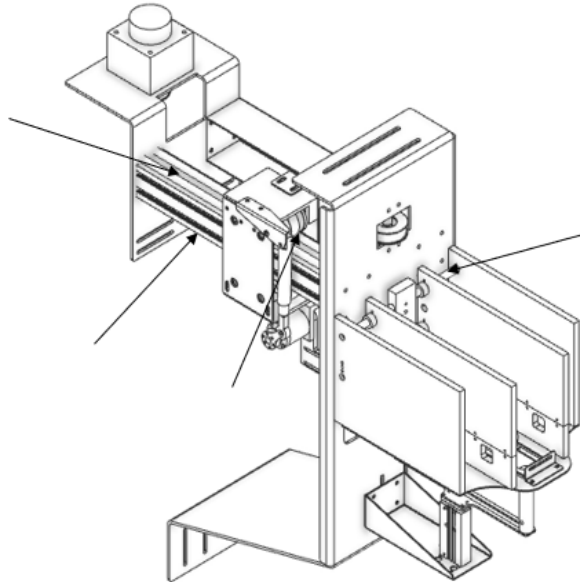
Procedure -

- Jog the pouch check arm assembly to the centre of gripper open assembly at station no 4
- Press and hold HPR for 2 sec

7.Lubrication

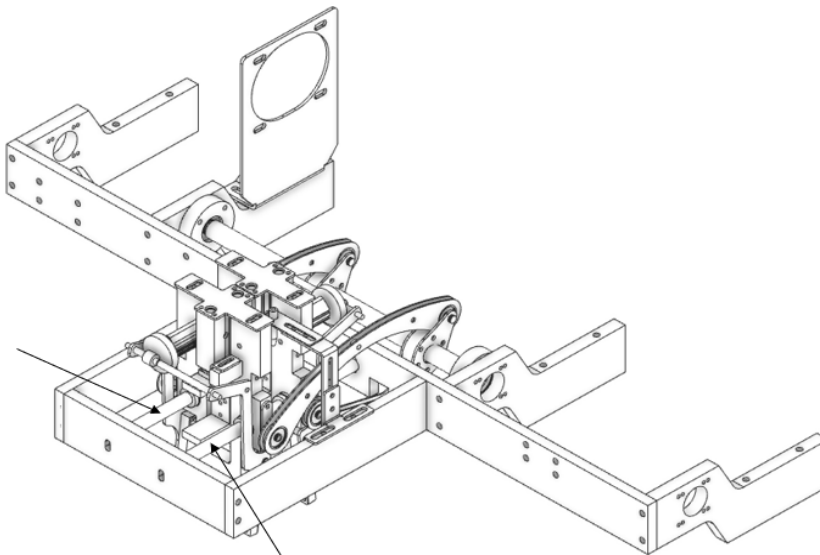
LUBRICATION POINTS

A. PPU Assembly



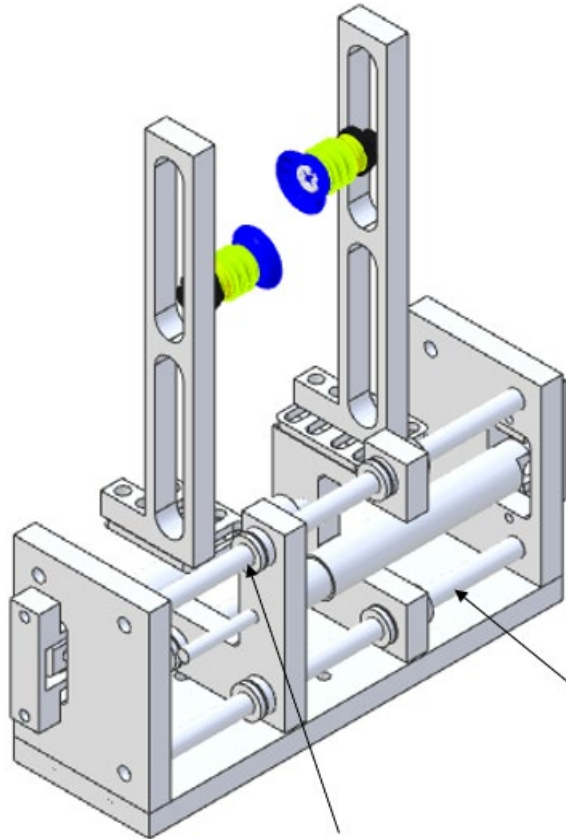
*PPU Guide Rods & bearings

B. Operation Assembly



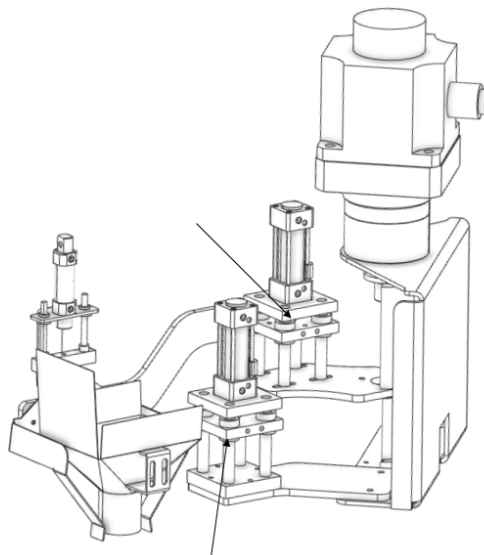
* Guide Rods & bearings

C. Gusset opening Assembly



* Guide Rods & bearings

E. Pouch Check Assembly



* Guide Rods & bearings

8.Changeover Procedure

- Check the width of pouch by using scale/measuring tape.
- Set Grippers according to pouch width.
- Set PPU manually according to pouch width.
- Adjust PSA vacuum cups according to pouch length.
- Adjust gusset opening vacuum cups according to pouch length.
- Adjust Air flushing nozzle.
- Adjust pouch sensors position according to pouch.

Set weight parameters according to pack size on weighers HMI

9.Starting Procedure

- Switch ON main supply
- Switch ON LOTO
- Provide air supply
- Check air pressure (Maintain between 6-6.5 bar)
- Check servo home positions
- Check Filler status
- Switch machine to AUTO mode
- Press AUTO START